

Work Order ID 131050

131050

Page 1

March-26-15 1:38:32 PM

Item ID: 646.3715 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Doubler
 Start Date: 3/26/15 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: MW Date: 15-03-27 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3700	A								

110 0.00
 110 8 0 Jm 15-3-28
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg
 6061-040 Dwg Rev: A
 Prog Rev: A
 2-Deburr if necessary

120 0.00
 120 8 0 Jm 15-3-28
 QC Memo 0.00
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

BAG
\$38
9-89

MAR 30 2015

140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
140									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>27987</u>								
	1- Black Anodize as per Dwg 646.3700								
	2- PRIME AS PER DWG, SEE NOTE #2								
	Certification of Conformity is required								

APR 10 2015

150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.00							
Packaging									

8x 8015-04-24

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Material									
Operator									
Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(8)			DAS 38 9-89 MAY 01 2015
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.00							DAS 6 9-89 MAY 04 2015
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ MAY 05 2015

MLJ MAY 05 2015

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Picklist Print

Page 1

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Work Order ID: 131050

131050

Parent Item: 646.3715

646.3715

Parent Item Name: Strut Doubler

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			110	sf	152.1306	0.0434	(1)			

M6061T6S 040

Jm15-3-28

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

152.1306

m130312

5.1135

m130585

8.5501

m131352

138.467

131352

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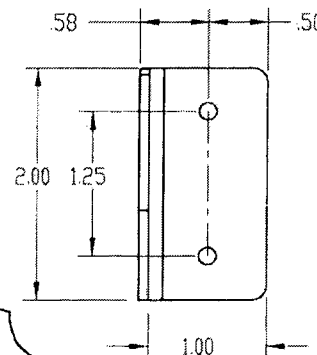
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR. <i>[Signature]</i>		MFG. <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS				EOR: D-12-010

SHEET 1, ZONE A2 IS:

IS

⚠ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

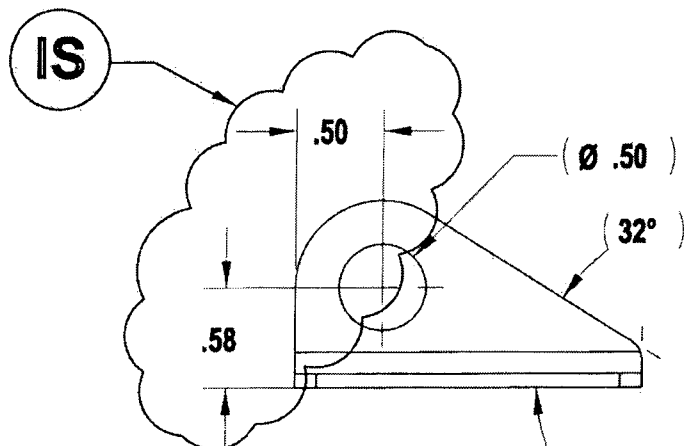
IS



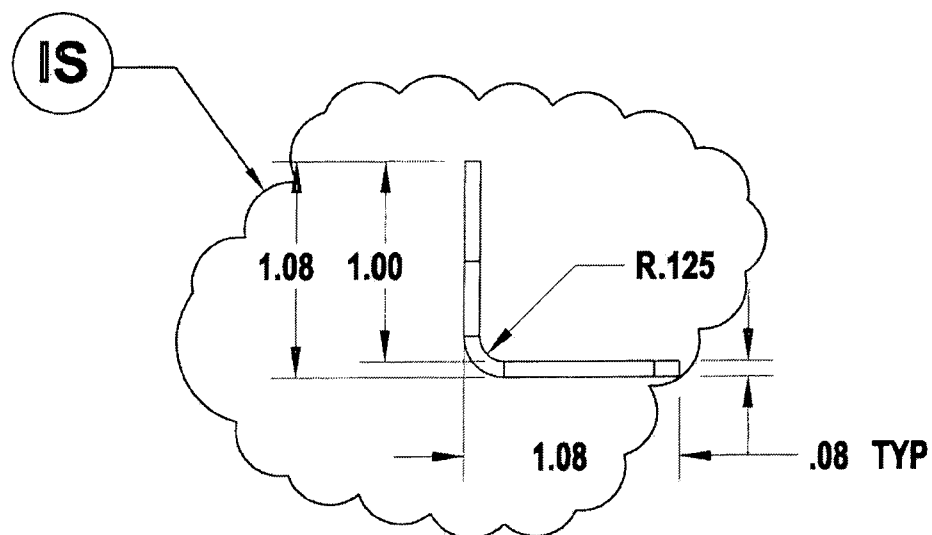
SHEET 7, ZONE B1 IS:

131050 MLC
15-03-27

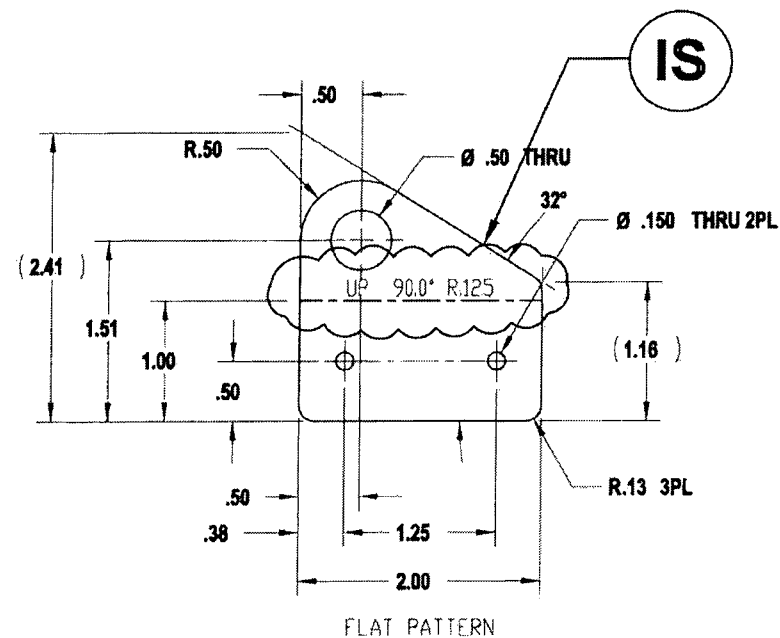
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED
☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BDM					☐ MAJOR ☒ MINOR	☐ YES ☒ NO



SHEET 7, ZONE C4 IS:



SHEET 7, ZONE D1 IS:



SHEET 7, ZONE B7 IS:

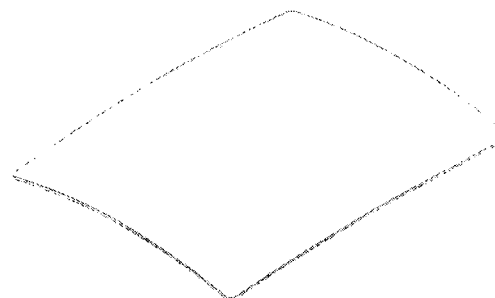
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
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REV	DESCRIPTION	DATE	APPROVED
A	REWORKED FOR BOW		10/25

NOTES:

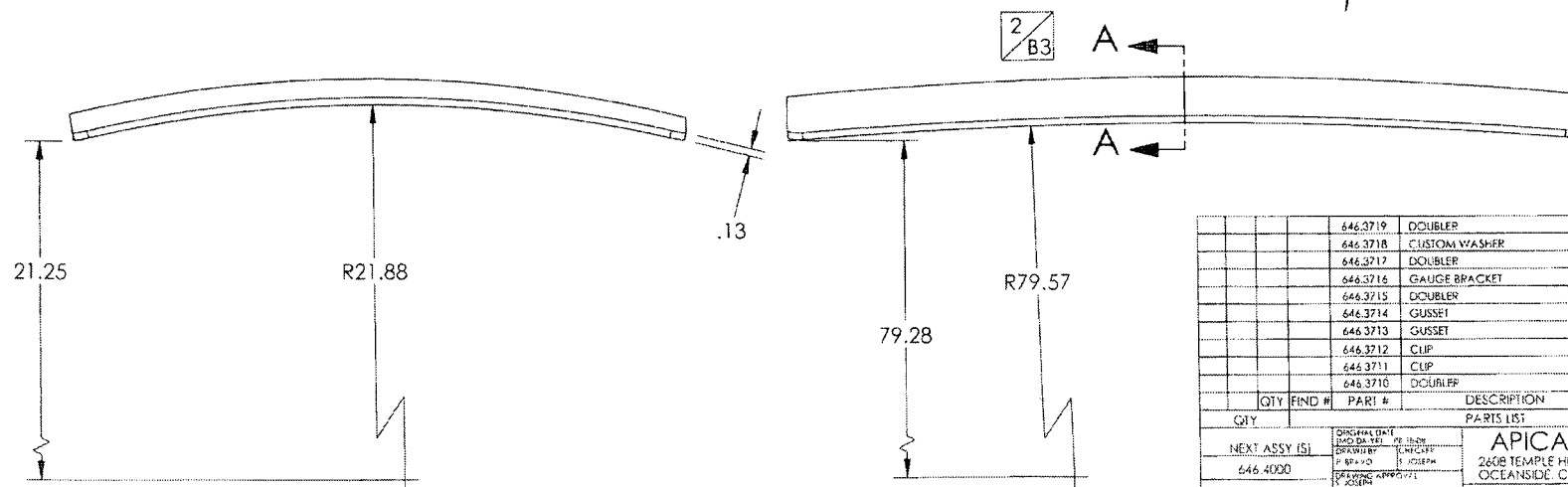
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

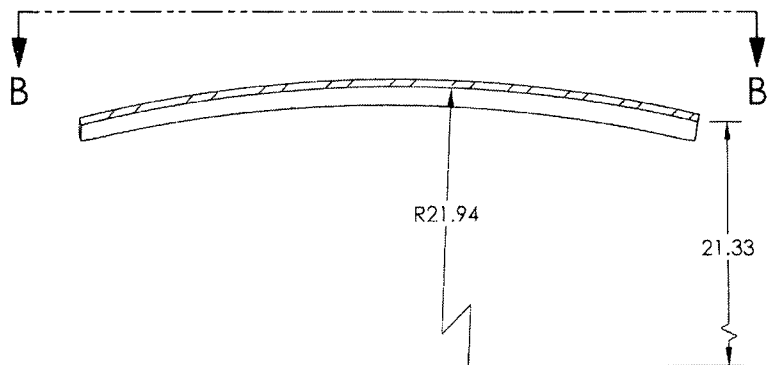
UNINCORPORATED ECN(s)

03702



			646.3719	DOUBLER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
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SECTION A-A



R395.138

R.13 4PL

13.51

10.49

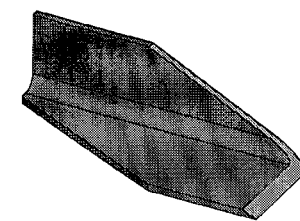
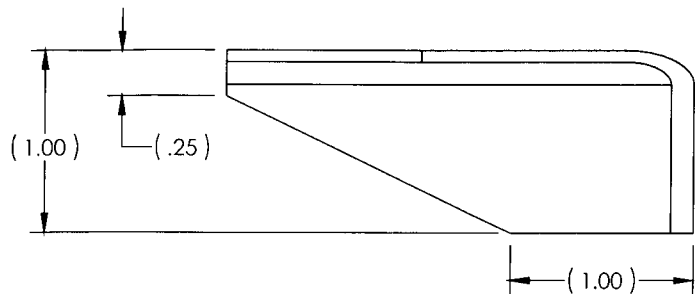
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SECTION B-B

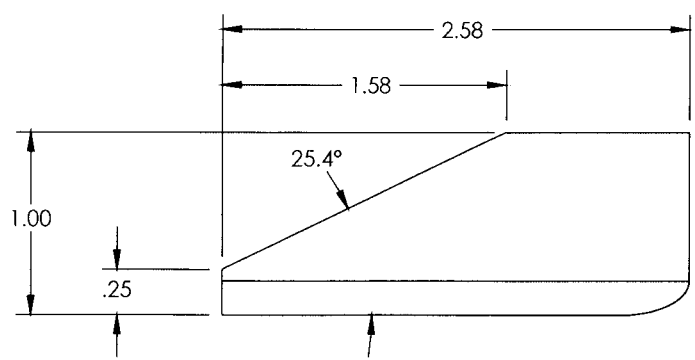
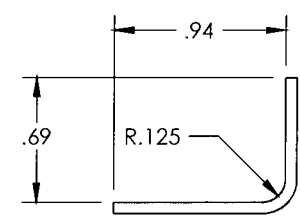
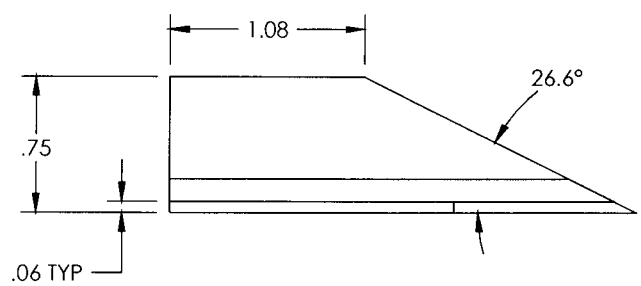
OPERATOR DATE INCHES 1/8"		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY	DATE	SHEETMETAL	
BY	DATE		
DESIGNED BY	DATE	646.3700	
CHECKED BY	DATE		
UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED	SCALE NONE	SHEET 2 OF 9
ALL DIMENSIONS ARE IN INCHES	ALL DIMENSIONS ARE IN INCHES		
3 PLACES DECIMALS & 0.1	3 PLACES DECIMALS & 0.1		
ANGLES 1/2°	ANGLES 1/2°		

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

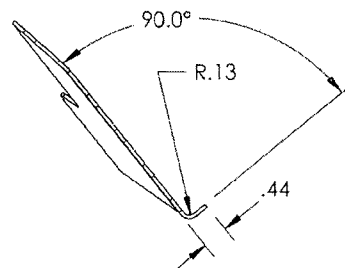


646.3711 SHOWN
646.3712 OPPOSITE

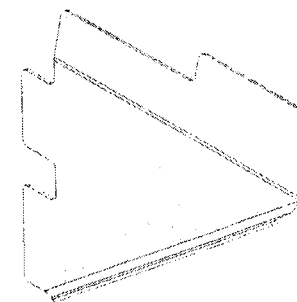


NEXT ASSY (S)		ORIGINAL DATE (DATE)	08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL	
DRAWN BY	CHECKER	DRAWING APPROVAL	S. JOSEPH		
P. BRAVO	S. JOSEPH	DATE	08-18-08		
CONTRACT NO.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
SHEET	CAGE CODE	DWG. NO.	REV.	SCALE: NONE	
B	07M26	646.3700	A	SHEET 3 OF 9	

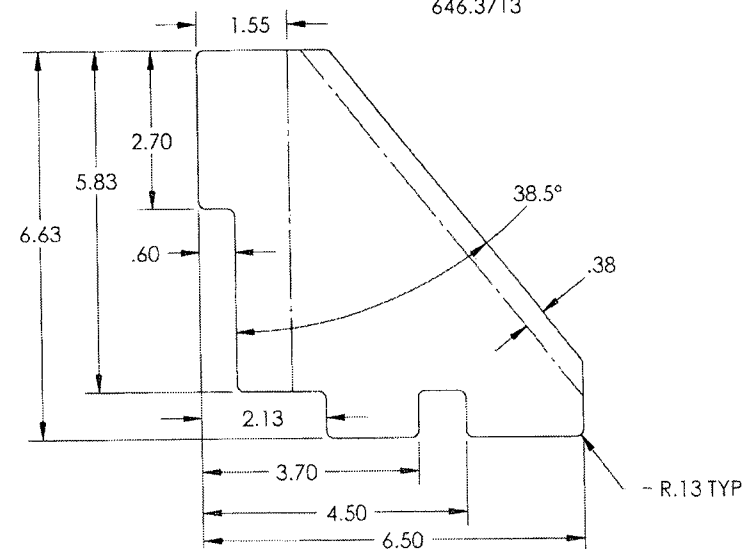
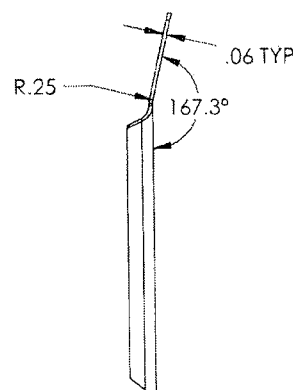
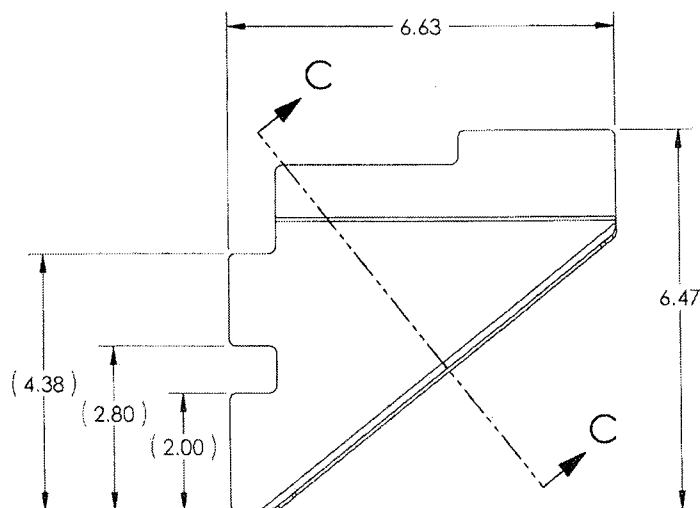
PERSONS			
KEY	DESCRIPTION	DATE	APPROVED



SECTION C-C



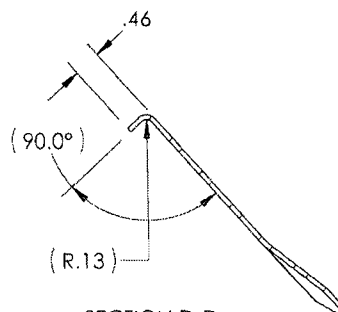
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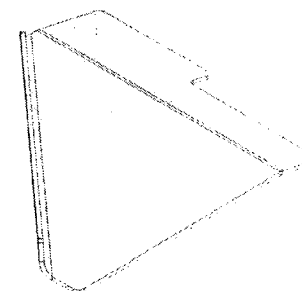
FLAT PATTERN

NEXT ASSY [S]	ORIGINAL DATE: 08-19-02 CIN: M3237 COUNTRY: U.S.A. P. NUM: 1 S. DATEPH: 1	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANASIDE, CA 92056-5512 (760)724-5303
	POSTAL CODE: 92056 CITY: OCEANASIDE COUNTRY: U.S.A. CONTACTING	SHEETMETAL
	UNITS: CMTS/PCB SECOND THIS MACHINE ARE IN STOCK FOR THE FOLLOWING 3 PRICES: CMT/PCB 1 2008 40000	SET CAGE CODE: 646.3700 REV: A
		DATE: 10-09-02 SHEET A OF B

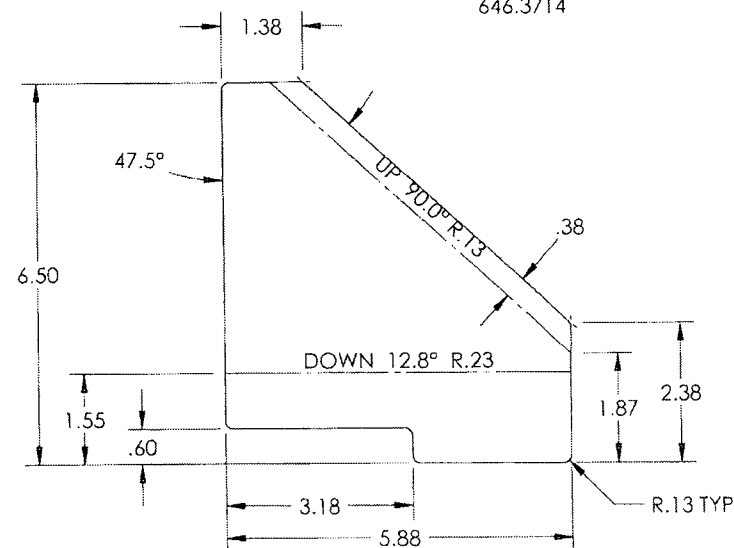
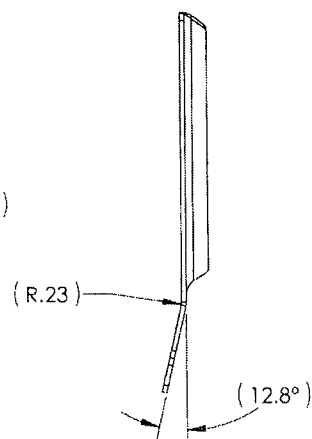
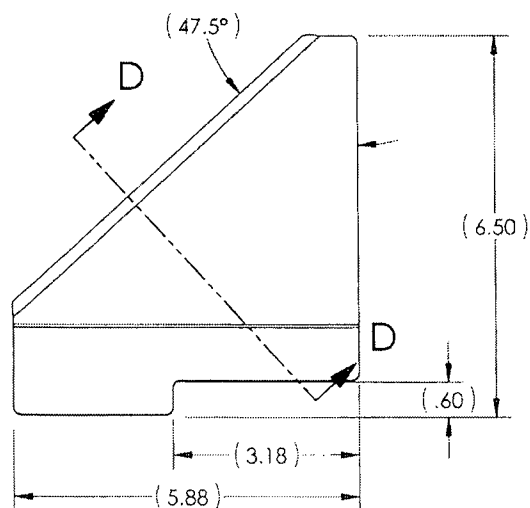
REVENUE			
REV	DESCRIPTION	DATE	AMOUNT



SECTION D-D



646.3714

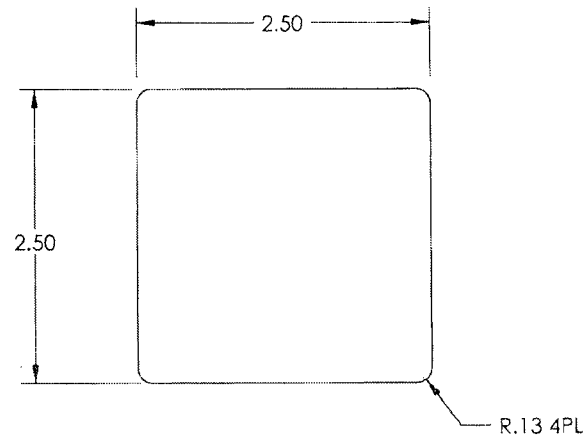


FLAT PATTERN

PROJECT DATE: 7/20/04 10:51 68 18 03		APICAL INDUSTRIES	
DRAWN BY: J. HETTER		2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3512 (760)724-5300	
PROJECT NO: 001001M		SHEETMETAL	
DRAWING APPROVAL: J. HETTER		1	
CHECKED BY: C. HETTER		1	
UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE: FINISH DIMENSIONS ± .015 UNFINISHED DIMENSIONS ± .030 HOLE DIMENSIONS ± .005		PART # OF CODE DWG NO B 67M16 646.3700	
SCALE NONE		SHEET 3 OF 4	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

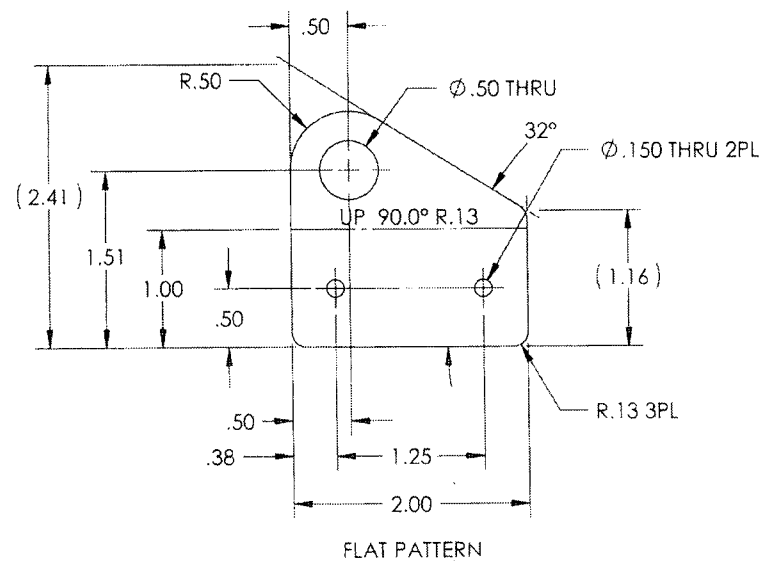
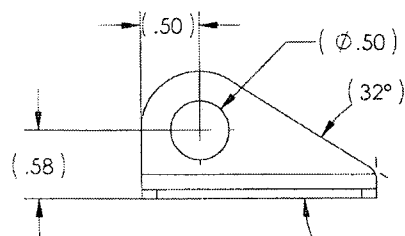
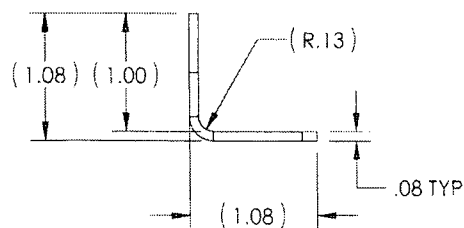
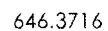
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3715

NEXT ASSY (S)		ORIGINAL DATE 06-18-03	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 17601724-5300	
		DRAWN BY P. BAYCO		
		CHECKED D. J. HILL		
		DESIGNED BY T. J. HILL		
		APPROVED DATE	SHEETMETAL	
		CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES 1° ±			SHEET CODE B 07M26	QREL NO 646.3700
			SCALE NONE	SHEET 5 OF 9

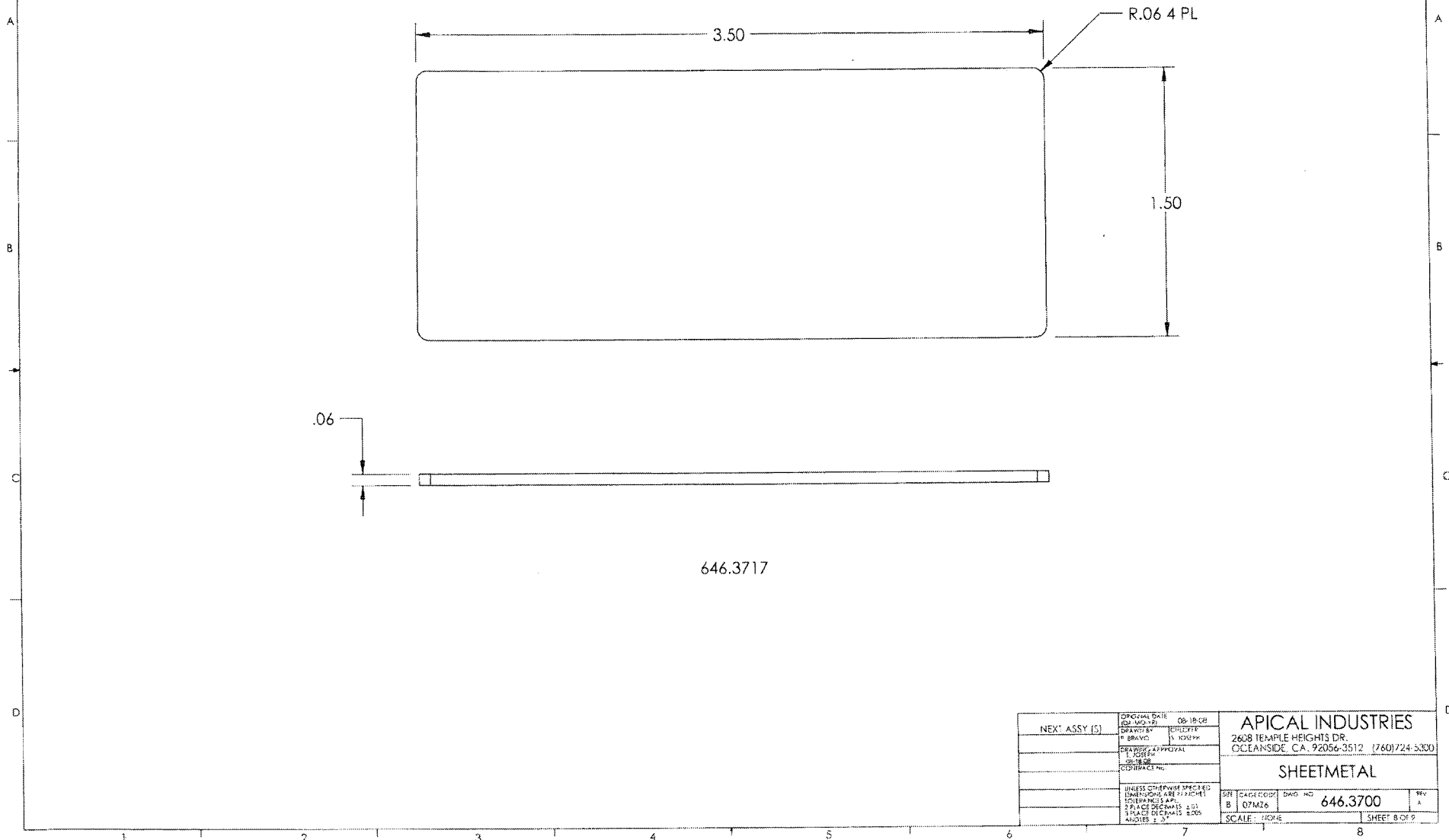
REVIEWS			
REV	DESCRIPTION	DATE	APPROVED



NEXT ASSY [5]	ORIGINAL DATE	08/15/08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3512 (760)724-5300	SHEETMETAL	SIZE	C/A CODE	CNOG NO	646.3700	P/N
	REV	1							
	P. DWA ID	12000000							
	DATE	12/08/08							
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS DECIMALS FRACTIONS								

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

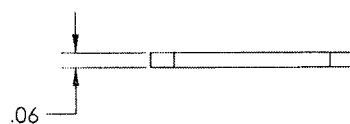
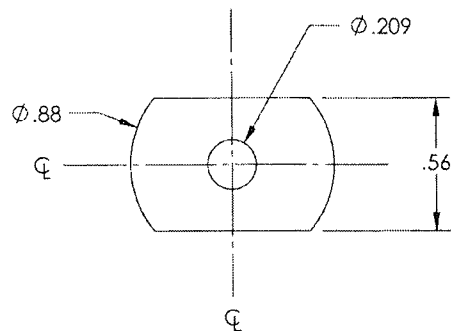
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



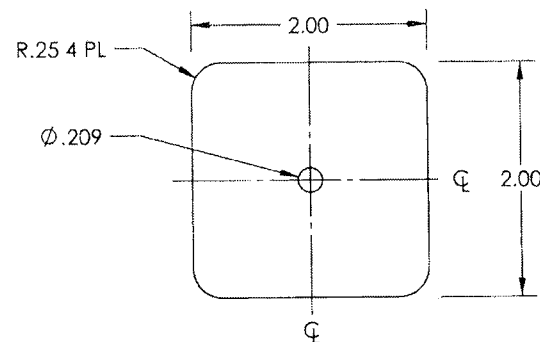
NEXT ASSY (5)		ORIGINAL DATE 08-18-08	APICAL INDUSTRIES	
DRAWN BY S. K. K. K.		DESIGNED BY S. K. K. K.	2608 TEMPLE HEIGHTS DR.	
CHECKED BY I. K. K. K.		APPROVED BY I. K. K. K.	OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CONTRACT NO.		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	SHEETMETAL	
TOLERANCES ARE: FRACTIONS DECIMALS ANGLES		±.01 ±.005 ±.01	DWG. NO. 646.3700	REV. A
SCALE: 1:1		SHEET 8 OF 9		

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REV.	DESCRIPTION	DATE	APPROVED



646.3718



646.3719

NEXT ASSY IS	ORIGINAL DATE (MM-DD-YY)	08-16-08	APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	CHECHU		
	P. BRAND	S. ROSEN	SHEETMETAL	
	DRAWING APPROVAL	S. ROSEN		
	DATE	08-16-08	SHEETMETAL	
	DATE	08-16-08		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES	1/16 1/32 1/64 ±.01 ±.005 ±.010 1° 5'	SERIAL CODE 8 07M16	DWG. NO. 646.3700
			SCALE: 1X=1X	SHEET 6 OF 5



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27987**

Purchase Order Date 4/1/2015

PO Print Date 4/16/2015

Page Number 2 of 8

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

131050

646.3715 STRUT
DOUBLER REV. A

4/24/2015

8.00

\$6.25

\$50.00

Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total:

\$50.00

4 130858

646.3812 GUSSET
BRACKETREV. N/C

4/24/2015

3.00

\$6.10

\$18.30

Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total:

\$18.30

5 130946

646.3913 STRUT
BRACKET REV. N/C

4/24/2015

3.00

\$6.10

\$18.30

Yes

4/24/2015

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total:

\$18.30

Note:

4/16/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
10 ea	Part: D5092-041 DOUBLER ASSEMBLY BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150292	Rev: B PO: PO27987	Line:
4 ea	Part: 646.3012 LOWER GUIDE HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150293	Rev: N/C PO: PO27987	Line:
8 ea	Part: 646.3715 STRUT DOUBLER HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150294	Rev: A PO: PO27987	Line:
3 ea	Part: 646.3812 GUSSET BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150295	Rev: PO: PO27987	Line:
3 ea	Part: 646.3813 STRUT BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER	Rev: N/C	

SP 15-04-24.



A.T.G. Industries Inc.
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PLATING DEPARTMENT
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Pack List

Number: 63666

Date: 24-Apr-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	Job: 20150309	PO: PO27987	Line:
2 ea	Part: D4703-043 LOCK PIN HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20150310	Rev: A PO: PO27987	Line:
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>24/4/15</u> CERTIFIED SIGNATURE : <u></u> RECEIVER SIGNATURE : _____			